

SPLIT PRELIMINARY ISSUE

Work Order ID 61884-

Wednesday, September 08, 2010 3:28:15 PM



Page 1

Item ID: D4177-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Radalt Guard Doubler

Start Date: 9/8/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

M

Date: *10-9-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4177	PA1

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: *PA1*

Prog Rev: *PA1*

2-Deburr if necessary

10 10-9-13

6

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10 10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61884

Wednesday, September 08, 2010 3:28:15 PM



Page 2

Item ID: D4177-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Radalt Guard Doubler

Start Date: 9/8/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check



QC

Quality Control

Memo

130

Chemical Conversion Coat per QSI005 4.1



HandFinish

Memo

Hand Finishing

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3



Powdercoat

Powder Coating

Memo

Start Time: 2:45pm
 Oven Temperature: 320°
 Finish Time: 3:15pm

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

-8 10/09/13

inspected to PM

dry only

BR 10-9-14.

24 10/09/15

(6) ✓

46 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61884

Wednesday, September 08, 2010 3:28:15 PM



Page 3

Item ID: D4177-1

Revision ID: PRELIM

Item Name: Radalt Guard Doubler

Start Date: 9/8/2010 Start Qty: 5.00

Required Date: 9/13/2010 Req'd Qty: 5.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>- inspect to p91 dry only</i> 0.00 <i>Sculps/10 (X6)</i>							

160 Packaging Packaging	Identify as per dwg & Stock Location: Memo	CA <i>JM</i>	0.00						
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170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							<i>10/09/29 JJ</i>
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POSITIVE RECALL
 EFFECTIVE 10/09 AUTH u
 RELEASED 10/09 DATE 10.09.22

110-0923

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 08, 2010 3:28:22 PM

Page 1

Work Order ID: 61884



Parent Item: D4177-1



Parent Item Name: Radalt Guard Doubler

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased		No		100	sf	104.9340	0.0625	0.328947 		10-9-13	

6061-T6 .063 Sheet

Location	Loc Qty	Loc Code
MAT21	104.934	
113608	104.934	

113608

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61884
Description: RADAR GUARD Double	Part Number:	D4177-1
Inspection Dwg: D4177 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	<u>10-9-13</u>	Date:	<u>10/09/13</u>	Date:	N/A
		Inspector to Date only			
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

Route / Bsm / DxF
Done

8 7 6 5 4 3 2 1

D

D

C

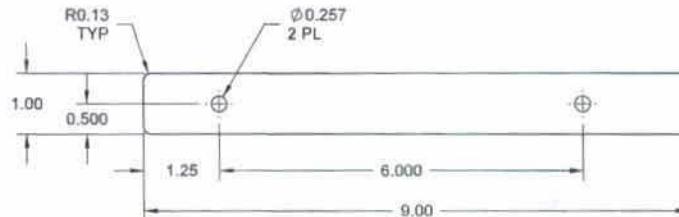
C

B

B

A

A



D4177-1 RADALT GUARD DOUBLER



SHOP COPY
RETURN TO
ENCLOSURE
UNCONTROLLED DOCUMENT
SUBJECT TO BE DESTROYED
WITH WORK ORDER
NO. A1884
PLC0-909

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

8 7 6 5 4 3 2 1

PRELIMINARY ISSUE

10.09.08

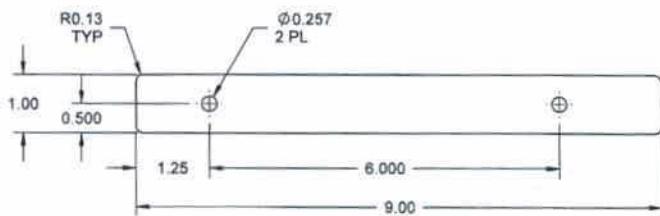
PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<u> </u>	<u> </u>	<u> </u>
DRAWN	<u> </u>	<u> </u>	<u> </u>
CHECKED	<u> </u>	<u> </u>	<u> </u>
MFG. APPR.	<u> </u>	<u> </u>	<u> </u>
APPROVED	<u> </u>	<u> </u>	<u> </u>
DE APPR.	<u> </u>	<u> </u>	<u> </u>
DATE	10.09.03	SCALE	NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4177 REV. PA1
SHEET 1 OF 1

TITLE RADALT GUARD DOUBLER

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D4177-1 RADALT GUARD DOUBLER

61884

RELEASED
2010-09-29
MP

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

A	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>A</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>C</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>D</i>	D4177	SHEET 1 OF 1
APPROVED	<i>E</i>	TITLE	SCALE
DE APPR.	<i>F</i>	RADALT GUARD DOUBLER	NTS
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